

Work Order ID 60200

Monday, June 28, 2010 3:20:57 PM



Page 1

Item ID:	D3065-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Leg Assembly Hi					
Start Date:	6/28/2010	Start Qty:	40.00			
Required Date:	7/5/2010	Req'd Qty:	40.00			
Reference:						

Approvals:	Process Plan:		Date:	10-6-29	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								
100	Small Fab	0.00							
	Small Fab								
	Memo	0.00							
	Assemble as per Dwg D3065 and Identify as D3065-041								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Memo	0.00							
	Quality Control								
120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								

EP 10/08/11 (40)

(counted) 40

SAD 10-08-11

(40) counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



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Monday, June 28, 2010 3:20:57 PM




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Item ID: D3065-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Leg Assembly Hi
Start Date: 6/28/2010 Start Qty: 40.00  Cust Item ID:
Required Date: 7/5/2010 Req'd Qty: 40.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/08/12 MF
10-8-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60200

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi



Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	70.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>59860</div> </div> <div> <div>Loc Qty</div> <div>52</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
<div> <div>WA</div> <div>58210</div> </div> <div> <div>18</div> </div> <div> <div>18</div> </div>													
D3065-3 Step Spacer		Manufactured	No			100	Each	24.0000	1	40			
<div> <div>Location</div> <div>GA</div> <div>59853</div> </div> <div> <div>Loc Qty</div> <div>14</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
<div> <div>WA</div> <div>48113</div> </div> <div> <div>10</div> </div> <div> <div>10</div> </div>													
D3065-5 Step Leg		Manufactured	No			100	Each	1.0000	2	80			
<div> <div>Location</div> <div>GA</div> <div>59851</div> </div> <div> <div>Loc Qty</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
<div> <div>1</div> </div>													

Ep 6/10/08/11

22

18

Ep 6/10/08/11

B60312 (26x)

14

0

Ep 6/10/08/11

1

B60311 (79x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 28, 2010 3:21:02 PM

Page 2

Work Order ID: 60200

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 40.00

Required Qty: 40.00

D3065-7 Manufactured No

100

Each

15.0000

1

40



Step Spacer



E/S 10/08/11
B60313 (25X)

Location

Loc Qty

Loc Code

GA

15

59854

15

15

MS20470AD4-4 Purchased No

100

Each

335.0000

30

1200



Rivet, Universal Head



E/S 10/08/11
M115156 (1200X)

Location

Loc Qty

Loc Code

ST319

122

112314

30

113368

92

ST321

213

114761

213

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

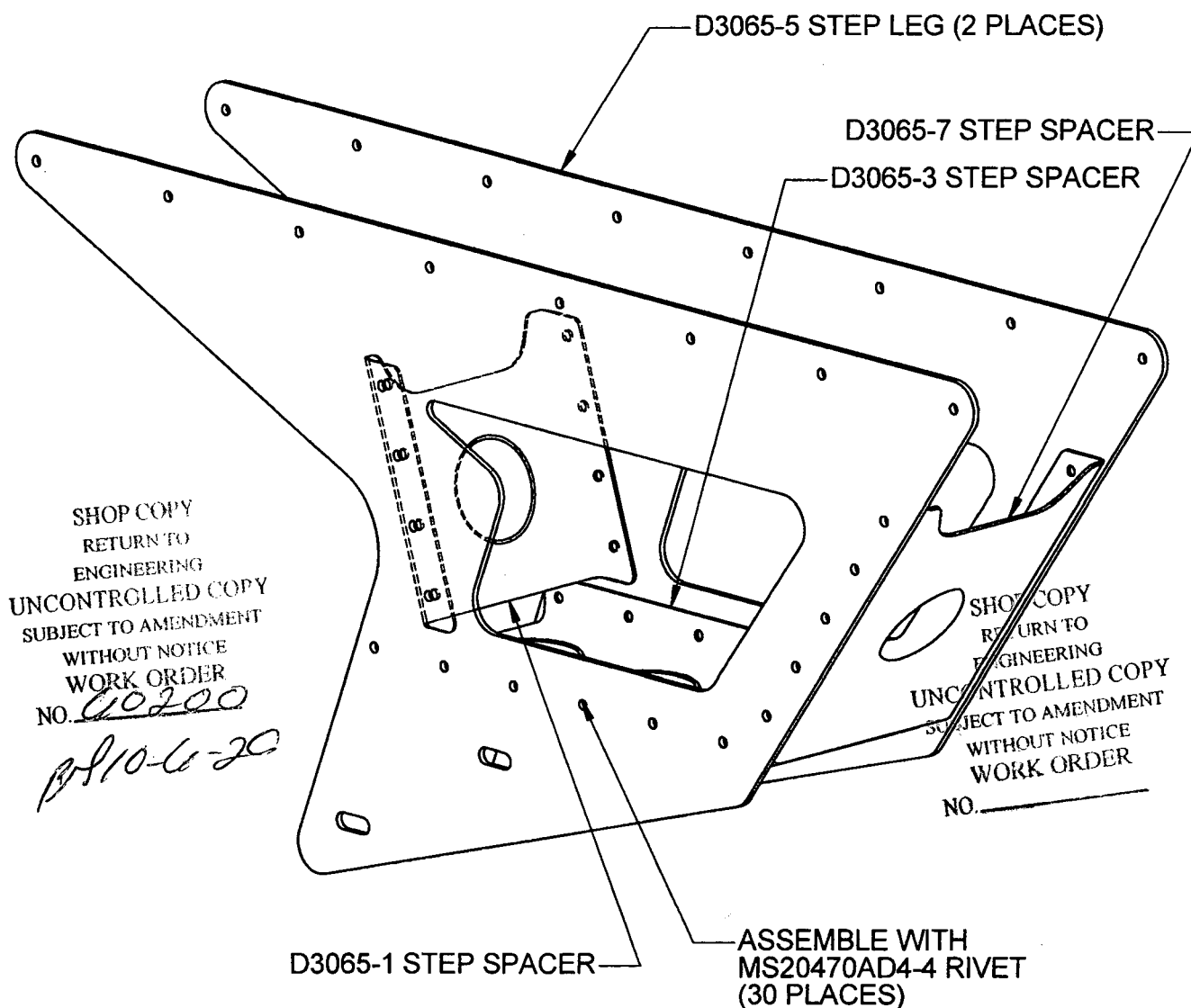
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06-06-20* *[Signature]***D3065-041 STEP LEG ASSEMBLY**

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

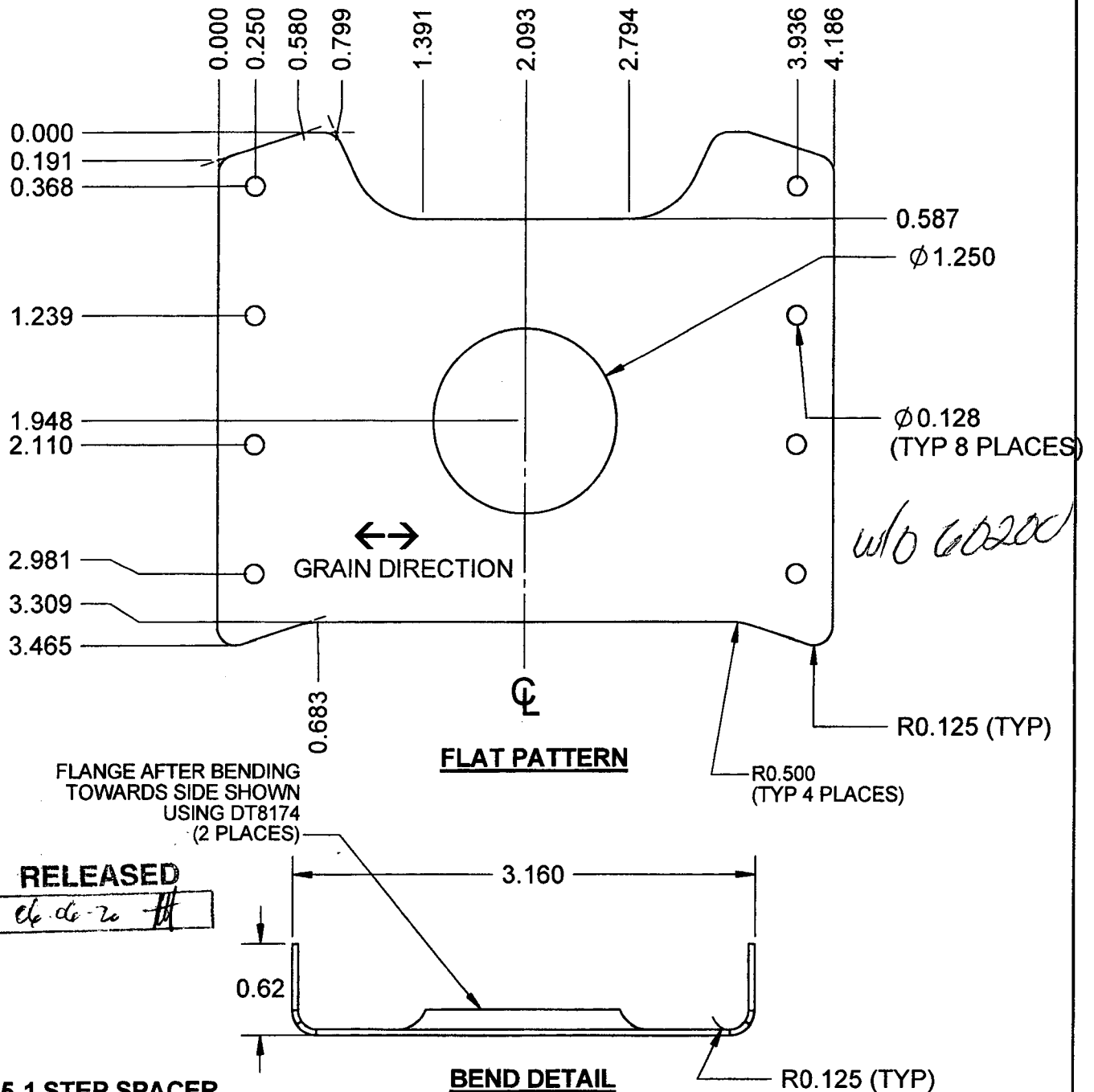
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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

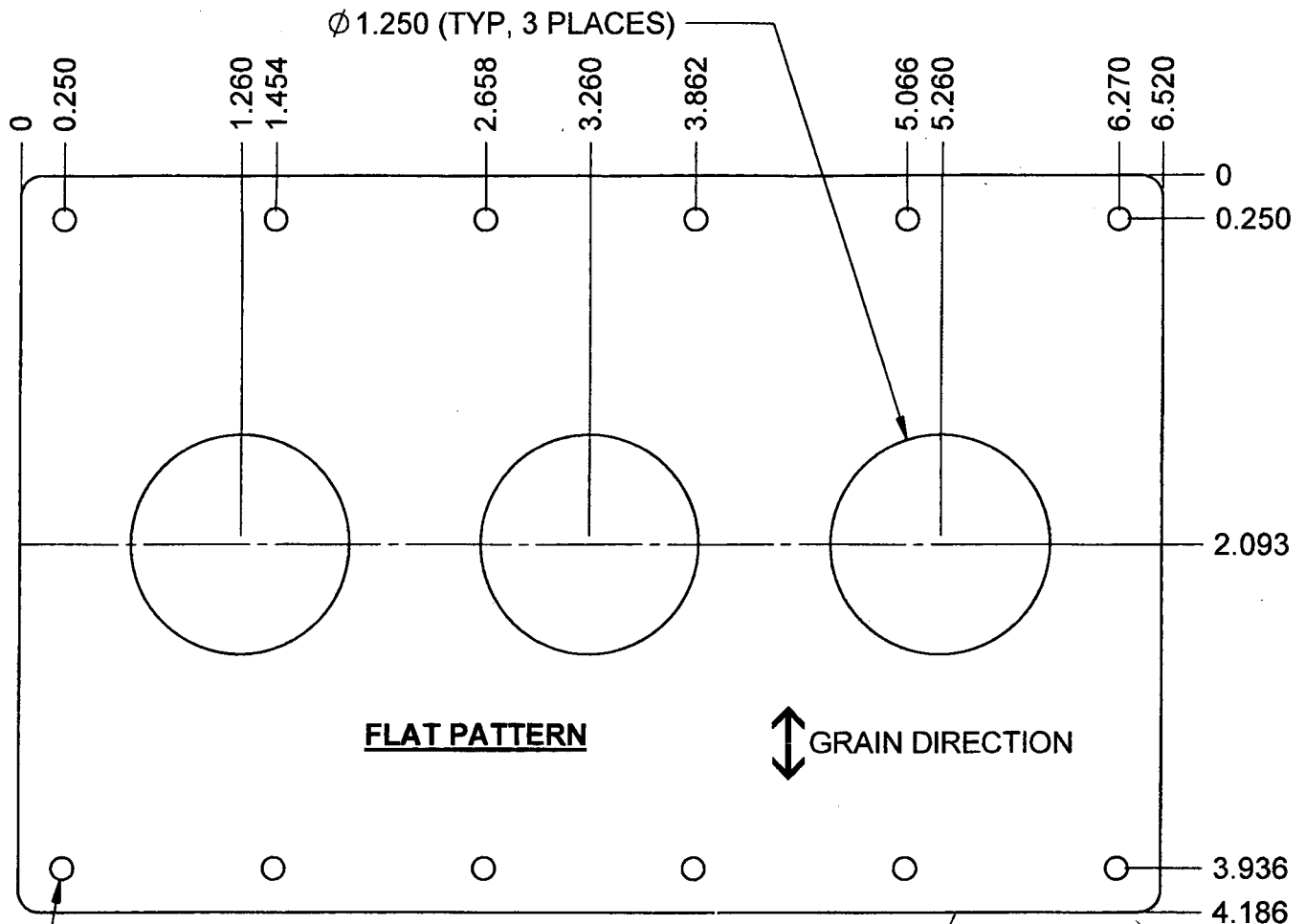
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

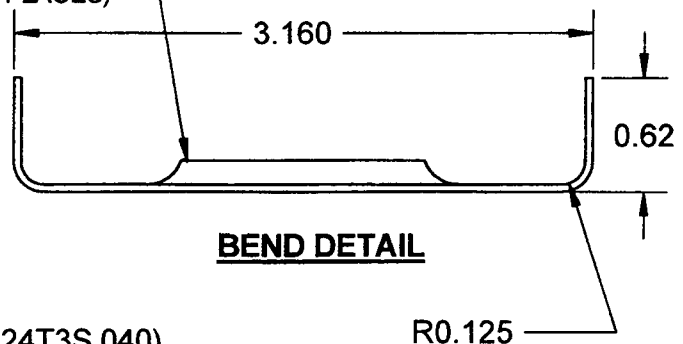


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 Oct 20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

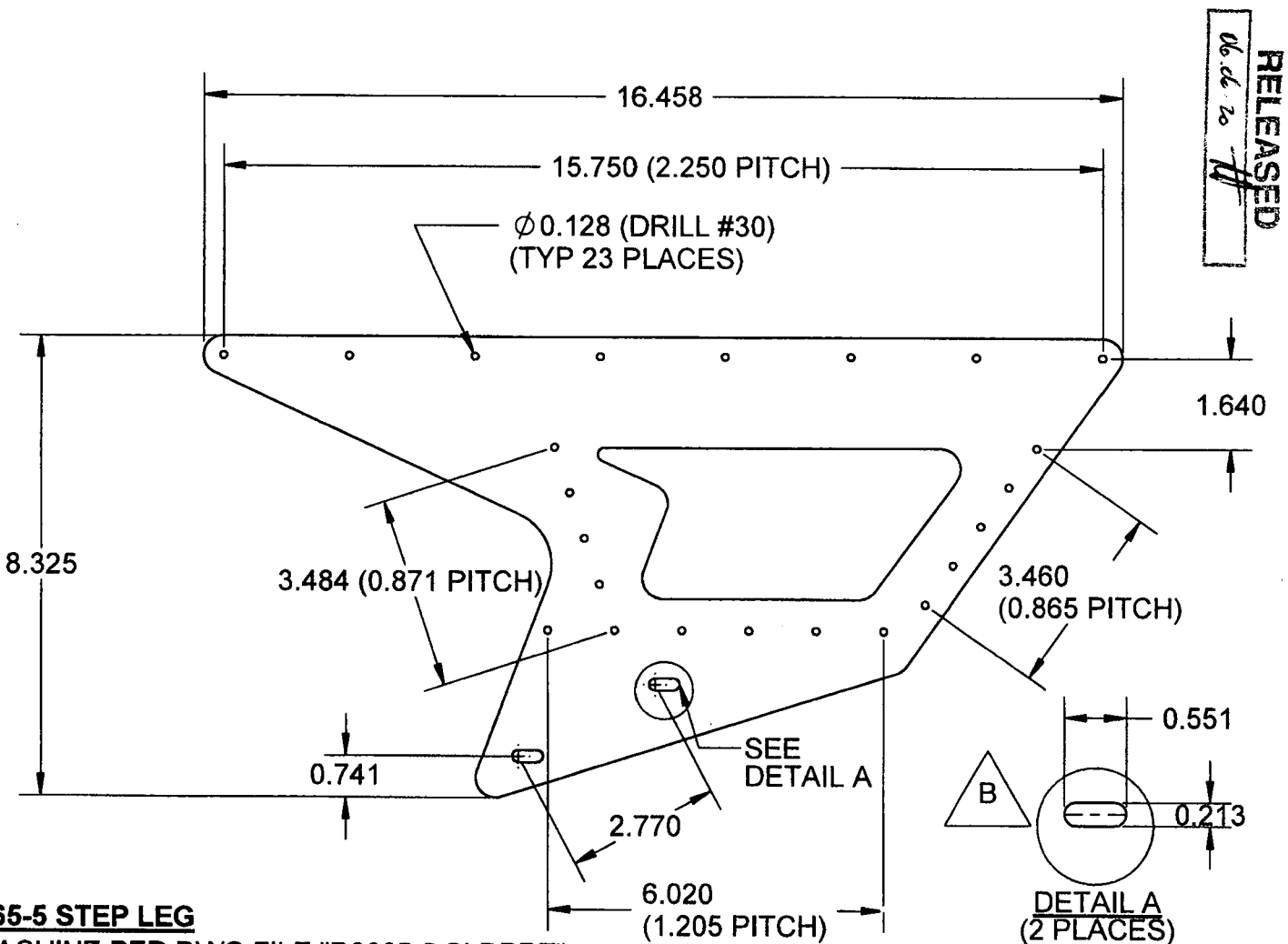
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	<i>CP</i>	DRAWN BY	<i>C.B.</i>	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO.
				D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	REV. B
				SHEET 4 OF 5
		SCALE	1:3	



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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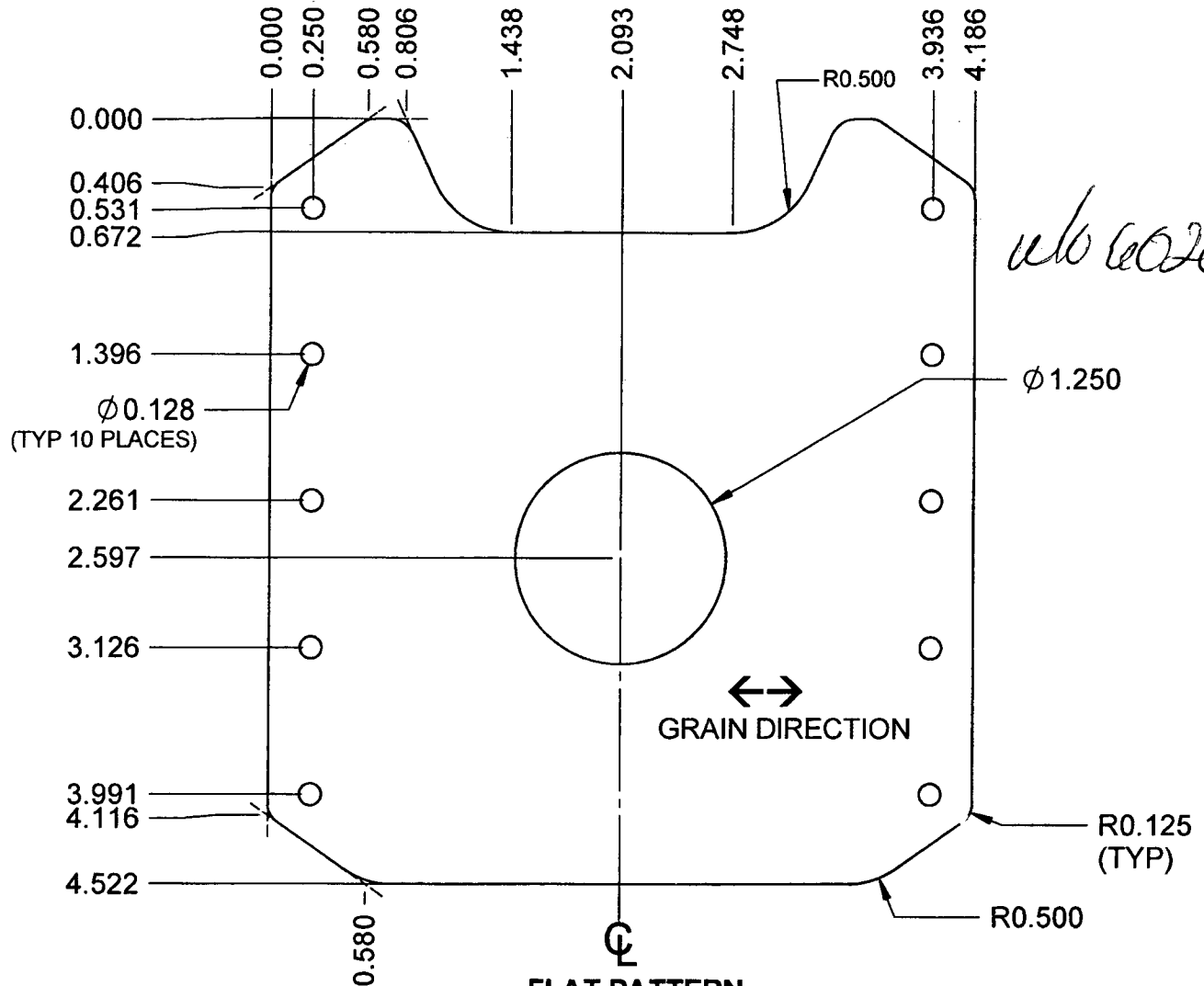
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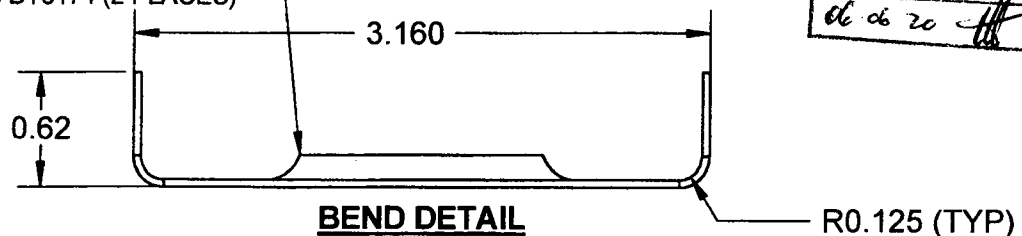
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

**RELEASED***06 06 20***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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